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Self-supporting Honeycomb Structure from Flexible Film  
Strips and Process for Manufacturing Same

Docket #70372

**SELF-CONTAINED HONEYCOMB STRUCTURE FROM FLEXIBLE  
FILM STRIPS AND METHOD FOR ITS PRODUCTION**

**FIELD OF THE INVENTION**

The present invention pertains to a honeycomb structure from flexible material strips, which are connected to one another, so that a self-supporting honeycomb structure is formed, as well as to a process for manufacturing same.

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**BACKGROUND OF THE INVENTION**

Corresponding honeycomb structures are used, among other things, as transparent or

opaque heat insulation, as filler material for partitions or as the core material in the manufacture of sandwich boards

If the honeycombs are used as heat insulation, low density is important in order to obtain good insulation values. If the honeycombs shall be used for sandwich boards, high compressive strength combined with high shear strength ~~shear strength~~ is necessary.

Similar honeycomb structures are described in the Auslegeschrift DT 2231959 B2 and in the Offenlegungsschrift DE 197 03 961 A1.

The Auslegeschrift DT 2231959 B2 describes a honeycomb from corrugated, rigid strips, which have an inherent stability, so that they can be stacked up on one another, and form a self-supporting structure, without the strips being welded or bonded to one another. The prerequisite for this is that the arches of the corrugations have such an arrangement that the shortest free distance between two adjacent peaks of the corrugation in each strip is smaller than the greatest free width of the valley of the corrugation (therefore, the corrugated strips cannot be pushed into one another).

Honeycombs of this type cannot be manufactured from flexible material strips, because a flexible strip cannot be bent into a rigid corrugated shape.

Honeycombs of this type are used as the core for sandwich boards made of metal, e.g., in the manufacture of aircraft.

5 A honeycomb structure made of flexible film strips is described in the Offenlegungsschrift DE 197 03 961 A1, wherein the film strips are welded onto one another in the corrugated form, so that a self-supporting honeycomb is formed. The principal difference from DT 2231959 B2 is that flexible strips are used here and a honeycomb is generated only when the strips are connected to one another by welding or bonding in the transition area from the horizontal and vertical partial areas of the corrugated strips arranged one on top of another. The residual stress (restoring behavior) of the flexible strips ensures that the honeycomb is more rigid and stable than a honeycomb made of pre-corrugated webs. A honeycomb is formed which is similarly bulged as the honeycomb from DT 2231959 B2 and has a nearly isotropic behavior whether it is loaded mechanically in the vertical or horizontal direction. One drawback is that this honeycomb cannot be compressed without distortions developing in the structure. Another drawback of this honeycomb which is linked with the process is the optically nonuniform edge structure. Since individual film strips are welded to one another, the overhanging film strips overlap at the lateral edges in parallel to the direction of production. To obtain a clean edge closure, an edge strip must be cut off, as a result of which drawbacks arise in terms of costs due to clipping.

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### SUMMARY AND OBJECTS OF THE INVENTION

The basic object of the present invention is to improve a honeycomb of the type mentioned in the introduction such that a self-supporting honeycomb is formed from flexible strips, which has a clean edge structure and can be compressed in a direction in parallel to the direction of production.

5     ~~This object is accomplished according~~     According to the present invention ~~in a~~  
~~honeycomb according to claim 1 by a~~ self-supporting honeycomb beingis provided  
manufactured from flexible strips, which honeycomb consists, however, contrary to DE 197 03  
961 A1, of horizontal, bent partial areas arranged at right angles to one another in parallel to  
the direction of production and straight vertical partial areas.

10     In addition, the bonded or weld seam of the honeycomb being described here ~~consists~~  
~~ofis located at~~ straight; vertical partial areas rather than of the horizontal and vertical partial  
areas of the corrugated strips arranged one on top of another (or in other words, at the edges  
of the parallelepipedic cavities), as in DE 197 03 961.

15     These features, which are essential for the present invention, are characteristic of a  
compressible honeycomb, and the advantage is above all that a compressed honeycomb can be  
transported at a substantially lower cost. Moreover, there are applications, e.g., as heat  
insulation, which require a small hole diameter, which can be obtained simply by compressing  
the honeycomb. Minimization of the hole diameter means a maximization of the heat insulation

factor (k value) for a honeycomb.

The honeycomb displays different behaviors under mechanical loading in the horizontal and vertical directions. Compression in parallel to the direction of production is possible without the structure of the honeycomb being distorted. A clean edge is formed on both sides of the honeycomb along the direction of production, because the respective outer film is welded  
5 endlessly to the honeycomb.

~~The According to another aspect of the invention, a device with the process steps, is provided with which a self-supporting honeycomb structure according to the present invention with the features of claim 1 can be manufactured, is disclosed in claim 5.~~

10 The device has a welding head, which comprises a plurality of welding sections or webs arranged in parallel to and at uniformly spaced locations from one another, all of which are equipped with a welding wire on the front side. Flat slide elements, which can be displaced forward and backward in parallel to the webs, are in contact with the lateral surfaces of the welding webs. There is a small gap between the slide elements, through which the film strips  
15 can be guided. In addition, the device has a comb with individual fingers, which can be moved into and withdrawn from the honeycomb structure in front of the welding webs. The welding head and the finger comb are displaceable in parallel to one another.

In addition, the welding head and the finger comb can be pressed against one another.

The necessary U-shaped corrugated structure of the film strips is produced with the device by the lateral displacement of the welding head and the comb, and the film strips are subsequently welded to one another at the vertical partial areas.

5 Not only plastic films, but all types of flexible material strips can be connected to one another with the device, the only requirement being the weldability of the material.

The honeycomb structure according to the present invention as well as the process steps for manufacturing this honeycomb structure will be explained in greater detail below on the basis of the drawings attached. The various features of novelty which characterize the invention  
10 are pointed out with particularity in the claims annexed to and forming a part of this disclosure.  
For a better understanding of the invention, its operating advantages and specific objects attained by its uses, reference is made to the accompanying drawings and descriptive matter in which a preferred embodiment of the invention is illustrated.

### BRIEF DESCRIPTION OF THE DRAWINGS

15 In the drawings:

Figure 1 ~~shows~~ is a top view of a honeycomb structure according to the present

invention-

Figure 2 is top view of the device for manufacturing the honeycomb structure according to Figure 1 showing an individual process step;

5       Figure 3 is top view of the device for manufacturing the honeycomb structure according to Figure 1 showing another process step;

Figure 4 is top view of the device for manufacturing the honeycomb structure according to Figure 1 showing another process step;

10       Figure 5 is top view of the device for manufacturing the honeycomb structure according to Figure 1 showing another process step;

Figure 6 is top view of the device for manufacturing the honeycomb structure according to Figure 1 showing another process step;

Figure 7 is top view of the device for manufacturing the honeycomb structure according to Figure 1 showing another process step; and

15       Figure 8 is top view of the device for manufacturing the honeycomb structure according to Figure 1 showing still another process step.

### DESCRIPTION OF THE PREFERRED EMBODIMENT

Figure 1 shows honeycomb structure according to the present invention. The connection of the individual film webs<sub>1</sub> to the points designated by (4)<sub>1</sub> is possible by bonding

or, as was described above, by preparing a weld seam extending at right angles to the film web.

Figures 2-8 ~~to 8~~ show ~~a top view of~~ the device for manufacturing the honeycomb structure according to Figure 1 ~~with the individual process steps.~~

~~The device with the individual process steps, by means of which the honeycomb structure.~~ An example according to the present invention can be manufactured from film webs by will be described below. The example includes individual process step for manufacturing a honeycomb structure with film webs using welded connections, will be described below as an example.

Figure 2 shows the welding head with the welding webs (6), which are equipped with welding wires (7) on the front side, and with the flat feed elements (8), which are in contact with the welding webs.

The welding head is located in the starting position, and the individual film strips (9) are inserted between the narrow gaps of the feed elements.

Figure 3 shows the first ~~process~~processing step. The feed elements (8) move forward until they project from the welding head over a certain distance. The finger comb (10) now moves between the feed elements and thus into the film strip until it stands in front of the welding head over the full welding height



The feed elements (8) move back again behind the welding plane corresponding to Figure 4. The welding head and the finger comb (10) are now displaced in parallel horizontally by an amount corresponding to twice the distance between two welding spots. The first welding of the film takes place in this position, the welding head and the welding fingers being pressed onto one another

According to Figure 5, the fingers (10) again move out of the film strip (9). The feed elements (8) then move forward and the film structure welded together is fed. The welding head again moves back into the starting position by an amount corresponding to twice the space between two welding spots.

The fingers (10) then move again into the film structure corresponding to Figure 6.

Figure 7 shows how the slides (8) move back behind the welding plane.

The welding head and the fingers (10) are now displaced in opposite directions. Pressing on of the welding head with the fingers (10) and the film welding operation will again take place.

The fingers (10) then move again out of the film structure according to Figure 8 and the

cycle of steps begins anew with step 1 (Figure 3).

## Abstract

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5        While a specific embodiment of the invention has been shown and described in detail to  
illustrate the application of the principles of the invention, it will be understood that the  
invention may be embodied otherwise without departing from such principles.

## ABSTRACT OF THE DISCLOSURE

A honeycomb structure with a plurality of flexible material strips which are arranged next to one another and are connected to one another is presented, ~~in which t.~~ The material strips have according to the present invention a corrugated shape with U-shaped cross section of essentially straight, vertical partial areas (3) and curved, horizontal partial areas (2); ~~wherein~~ t. The material strips are connected to one another at contact points (4) of the straight, vertical partial areas.

~~In addition, a device for manufacturing a honeycomb according to the present invention is disclosed, which has welding sections (6), by which t.~~ The flexible material strips (9) are guided by the welding sections (6), where the said material strips are welded to one another by means of a comb-like finger system (10) ~~by t.~~ The finger system or the welding sections being are laterally displaced by two sections and by a pressing operation taking place between the finger and the welding section; ~~which.~~ This presses two material strips onto a heated welding wire (7), which leads to the thermal connection of the material strips.

Figure ~~t~~

Figure ~~t~~ through Figure 8

Figure ~~t~~

KEY:

Produktionsrichtung ~~=~~ Direction of production